












Date: Thursday, 26/10/2006 1:16:18 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 29013		
Estimate Number	: 10709		
P.O. Number	: N/A	Part Number	: D32101
This Issue	: 26/10/2006 S.O. No. : N/A	Drawing Number	: D3210 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 29013	Material	: N/A
Written By	: <u>W</u>	Due Date	: 30/10/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now On Waterjet 06-10-24 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S080	2024-T3 .080 sheet	
			
Comment: Qty.: 2.6177 sf(s)/Unit Total: 20.9412 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify as D3210-1 m18481 m106 1204 (8) Batch: M17695 M17695 m1 06 11 10			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3210 Dwg Rev: A A m1 06 12 04 (8) Prog Rev: A A m1 06 11 11 (8) 2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE m1 06 12 04 (8) PTO			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK m1 06 12 04 (8)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr m1 06 12 06 (8)			

Date: Thursday, 26/10/2006 1:16:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29013

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

06/12/20 X 8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100700

M-L / AM

06/12/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/12/21

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5789*

06/12/21

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

Job Completion



16 06/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 20 Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
m1 06/11/11	2.0	2 pieces scrap because Program holes was 0.128 but was supposed to be 0.141	<i>[Signature]</i> 06/11/11	Scrap 3. Destroy replace 2 pieces	m1 06/11/11	<i>[Signature]</i> 07-01-02	<i>[Signature]</i> 06/11/11	<i>[Signature]</i> 07-01-02
06/11/13	3	8 parts scrap due to wrong DXF	<i>[Signature]</i> 06/11/13	destroy and replace	m1 06/11/13	<i>[Signature]</i> 06/11/13	<i>[Signature]</i> 06/11/13	<i>[Signature]</i> 07-01-02

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:41 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29013
Estimate Number : 10709
P.O. Number :
This Issue : 10/16/2006 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 25251
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 05-11-17 JLM

Drawing Name : DOUBLER
Part Number : D32101
Drawing Number : D3210 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 10/30/2006 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 2.6177 sf(s)/Unit Total : 20.9412 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)Identify as D3210-1
Batch: _____

2.0 SHEAR SHEAR



Comment: SHEAR
Cut blanks: 20.200" x 17.780" (+0.000/-0.010)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3210-1 as per Folio FA347 and Dwg D3210
Stack of 4

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

DART



DESIGN	DRWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3210	SHEET 1 OF 1
03.09.03		TITLE	SCALE
		DOUBLER	1:3
A	03.09.03	NEW ISSUE	

D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

DETAIL A
SCALE 2:3

